

Date: Monday, 7/30/2007 1:54:08 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE, INBOARD, LS, 206	
Job Number	: 33797	Part Number	: D26661	
Estimate Number	: 10820	Drawing Number	: D2666 REV. D	
P.O. Number	: N/A	Project Number	: N/A	
This Issue	: 7/30/2007	S.O. No.	: N/A	
Prsht Rev.	: NC	Type	: MACHINED PARTS	
First Issue	: N/A	Material	: N/A	
Previous Run	: 32624	Due Date	: 8/28/2007	
Written By	: JLM 07.07.30			
Checked & Approved By				
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house process EC Est Rev:D As per Rev D 07-03-19 JLM			

## Additional Product

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 2X6X6.25 Issue material from stock: Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length Batch No. BG 07.04.20 22		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number. 1-Inspect part number and batch number are programmed correctly. 2-Fixturing Inspection last completed on N/A by N/A 3-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 6-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 8-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 9- Debur BG 07.04.20 22		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 
Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet BG 07.04.25 22		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE BG 07.04.25 22		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 07/09/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/30/2007 1:54:08 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, LS, 206

Job Number: 33797

Part Number: D26661

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



(D8) →

Comment: SECOND CHECK

JL 07/09/25

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(22x)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M. h

07/09/25

7.0 POWDER COATING POWDER COATING



(22)

m 105068

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BK

07-09-26

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



07/09/26 (22)

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



07/09/26 (22)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10.0 QC21 FINAL INSPECTION/W/O RELEASE



07/09/26 (22)

Comment: FINAL INSPECTION/W/O RELEASE

07/09/25

Job Completion



U 07/09/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/25	#	the STANDE was found with no key was cut for the radio of the skid tube	Initial Chief Eng	Re machine key	BF 0109-25	✓	10/26 10:04Z	CM 10/25
		R.C. Human error		Re Aludine As per QST 005,	BF 0109-25			

NOTE: Date & initial all entries

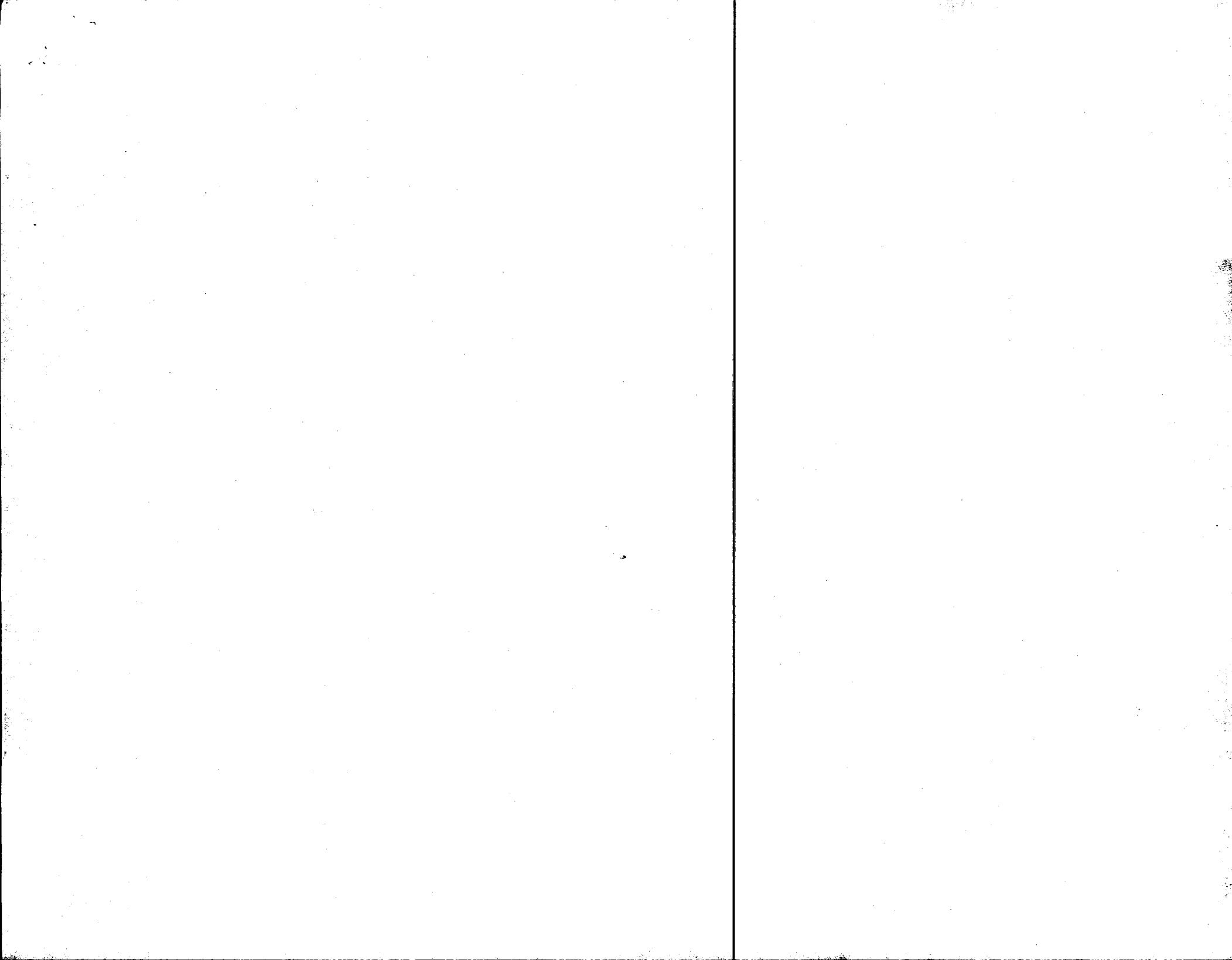
DART AEROSPACE LTD	Work Order:	33797
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.127	.127	.127	.127		
B	0.100	0.140		.120	.120	.120	.120		
C	2.470	2.510		2.497	2.497	2.497	2.497		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.228	.228	.228	.228		
F	1.313	1.343		1.330	1.330	1.330	1.330		
G	0.240	0.260		.253	.253	.253	.253		
H	0.615	0.685		.650	.650	.650	.650		
I	1.125	1.145		1.140	1.140	1.140	1.140		
J	0.990	1.010		1.000	1.000	1.000	1.000		
K	0.235	0.240		.239	.239	.239	.239		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.117	.117	.117	.117		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.010	6.010	6.010	6.010		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.506	.506	.506	.506		
S	0.313	0.318		.314	.314	.314	.314		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.315	0.322		.319	.319	.319	.319		
W	0.540	0.560		.557	.557	.557	.557		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	BS	Audited by:	SL
Date:	07.09.21	Date:	07/09/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DS1 9095, DS1 9102 & DS1 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	✓ JLM



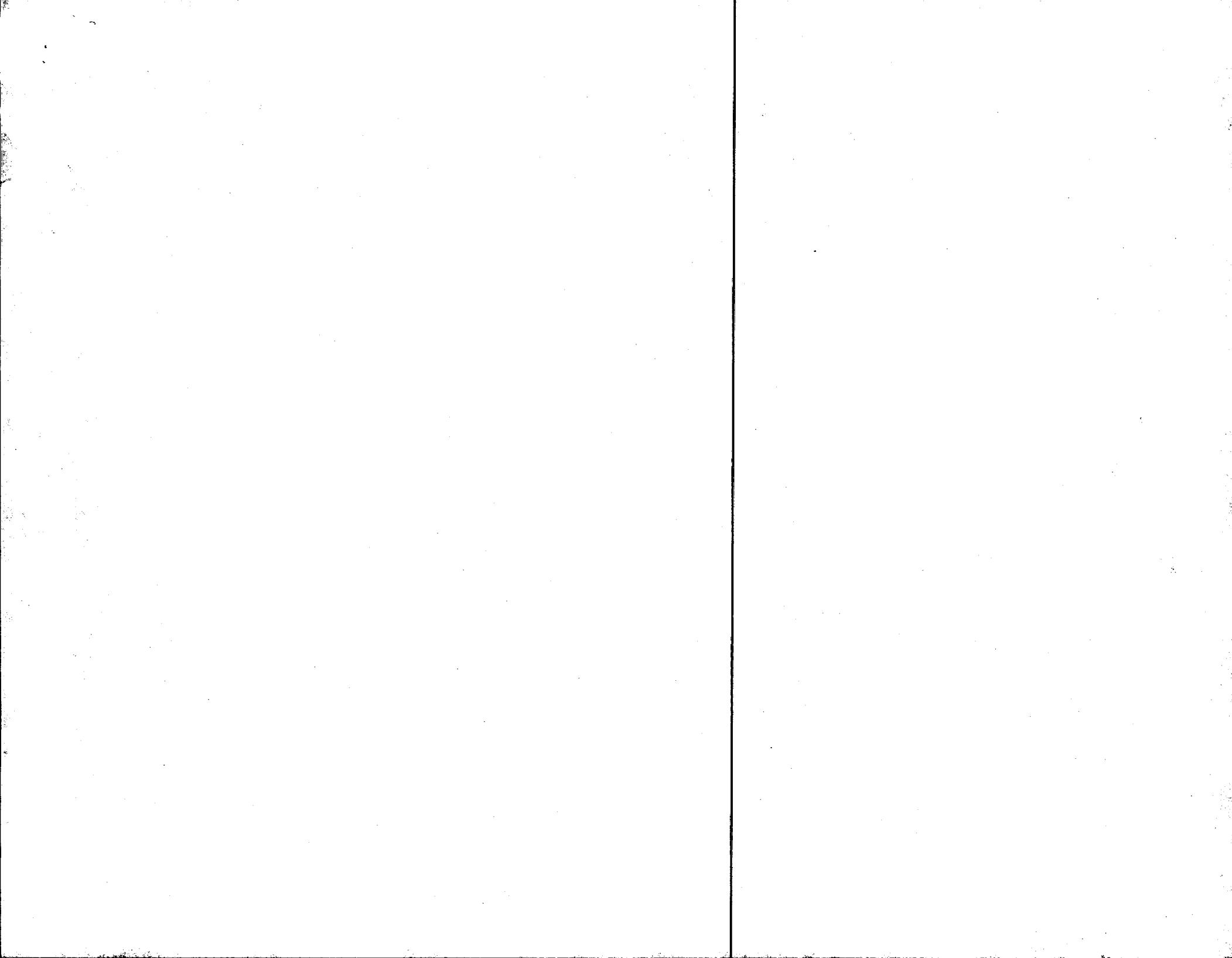
DART AEROSPACE LTD				Work Order:	33797
Description: 206 Saddle, Inboard, Left side				Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.127	.127	.127	.127		
B	0.100	0.140		.120	.120	.120	.120		
C	2.470	2.510		2.495	2.497	2.497	2.497		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.226	.226	.226	.226		
F	1.313	1.343		1.330	1.330	1.330	1.330		
G	0.240	0.260		.254	.254	.254	.254		
H	0.615	0.685		.650	.650	.650	.650		
I	1.125	1.145		1.140	1.140	1.140	1.140		
J	0.990	1.010		1.000	1.000	1.000	1.000		
K	0.235	0.240		.239	.239	.239	.239		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.116	.116	.116	.116		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.010	6.010	6.010	6.010		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.506	.506	.506	.506		
S	0.313	0.318		.313	.313	.313	.313		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.315	0.322		.319	.319	.319	.319		
W	0.540	0.560		.556	.556	.556	.556		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>TC</i>	Audited by:	<i>JL</i>
Date:	07/09/21	Date:	07/09/25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM <i>JK</i> <i>JL</i>	



DART AEROSPACE LTD	Work Order:	33797
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.125	.125	.125	.125		
B	0.100	0.140		.120	.120	.120	.120		
C	2.470	2.510		2.497	2.497	2.497	2.497		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.226	.226	.226	.226		
F	1.313	1.343		1.330	1.330	1.330	1.330		
G	0.240	0.260		.254	.254	.254	.254		
H	0.615	0.685		.650	.650	.650	.650		
I	1.125	1.145		1.140	1.140	1.140	1.140		
J	0.990	1.010		1.000	1.000	1.000	1.000		
K	0.235	0.240		.237	.238	.238	.238		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.116	.116	.116	.116		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.010	6.010	6.010	6.010		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510	-	.506	.506	.506	.506	-	
S	0.313	0.318		.314	.314	.314	.314		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.315	0.322		.319	.319	.319	.319		
W	0.540	0.560		.557	.557	.557	.557		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SG	Audited by:	SL
Date:	07.09.21	Date:	07/09/21

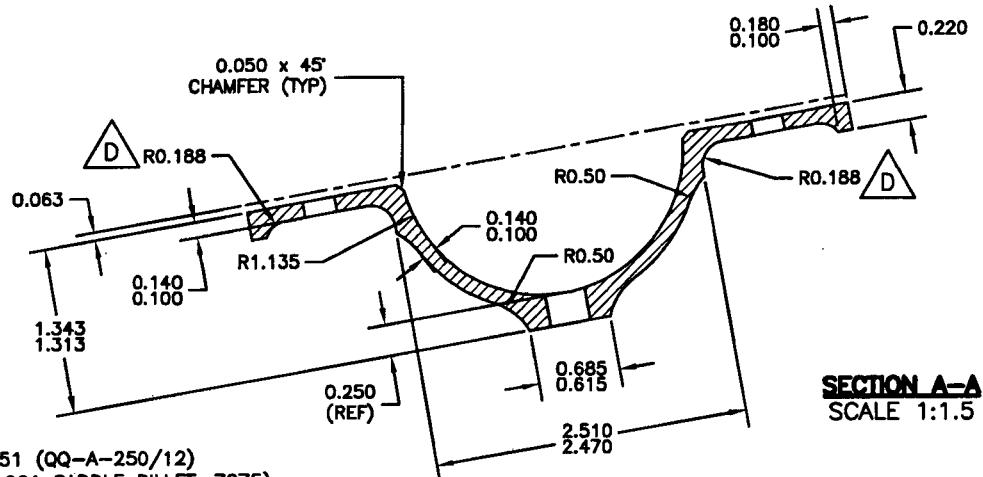
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	SL

**DART**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2666 REV. D SHEET 1 OF 1
DATE		TITLE SCALES 06.11.08 SADDLE FWD INSIDE HIGH 1:3
A	97.03.25	NEW ISSUE
B	97.07.11	ANGLE AND NOTES ADDED
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313

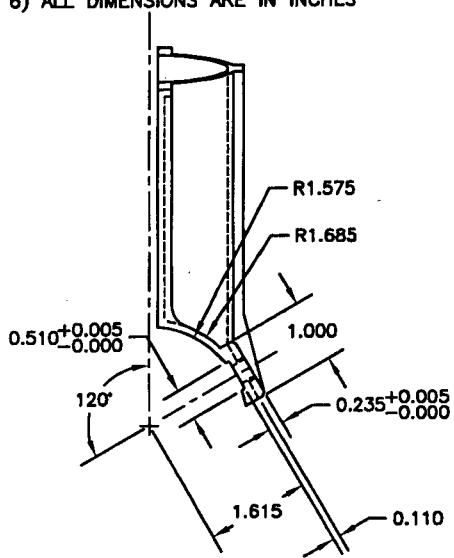
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07.02.12

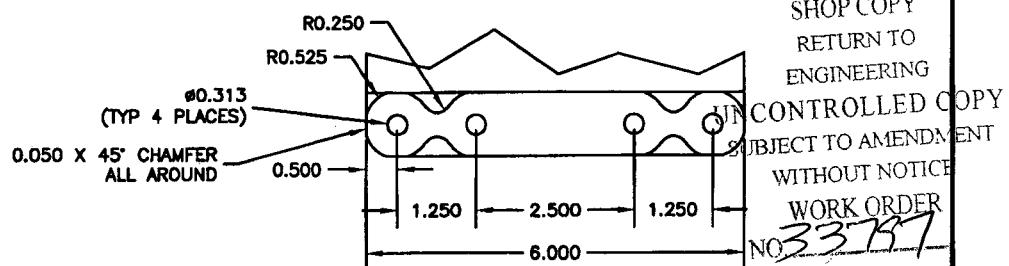
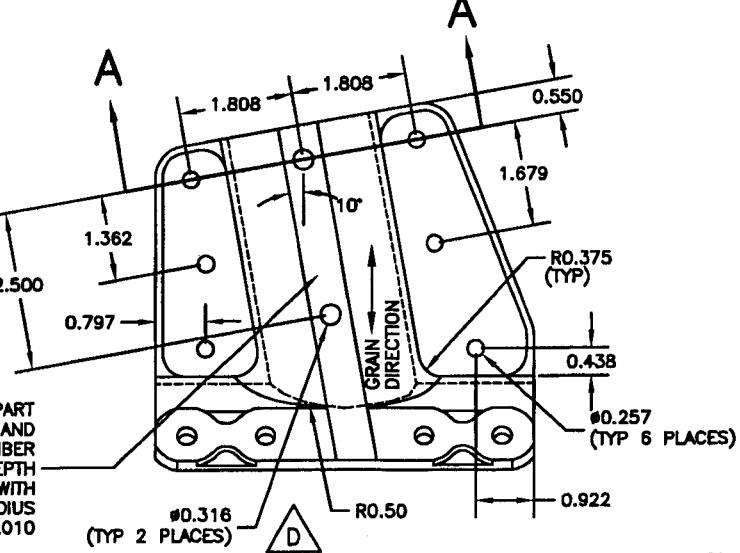


## NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

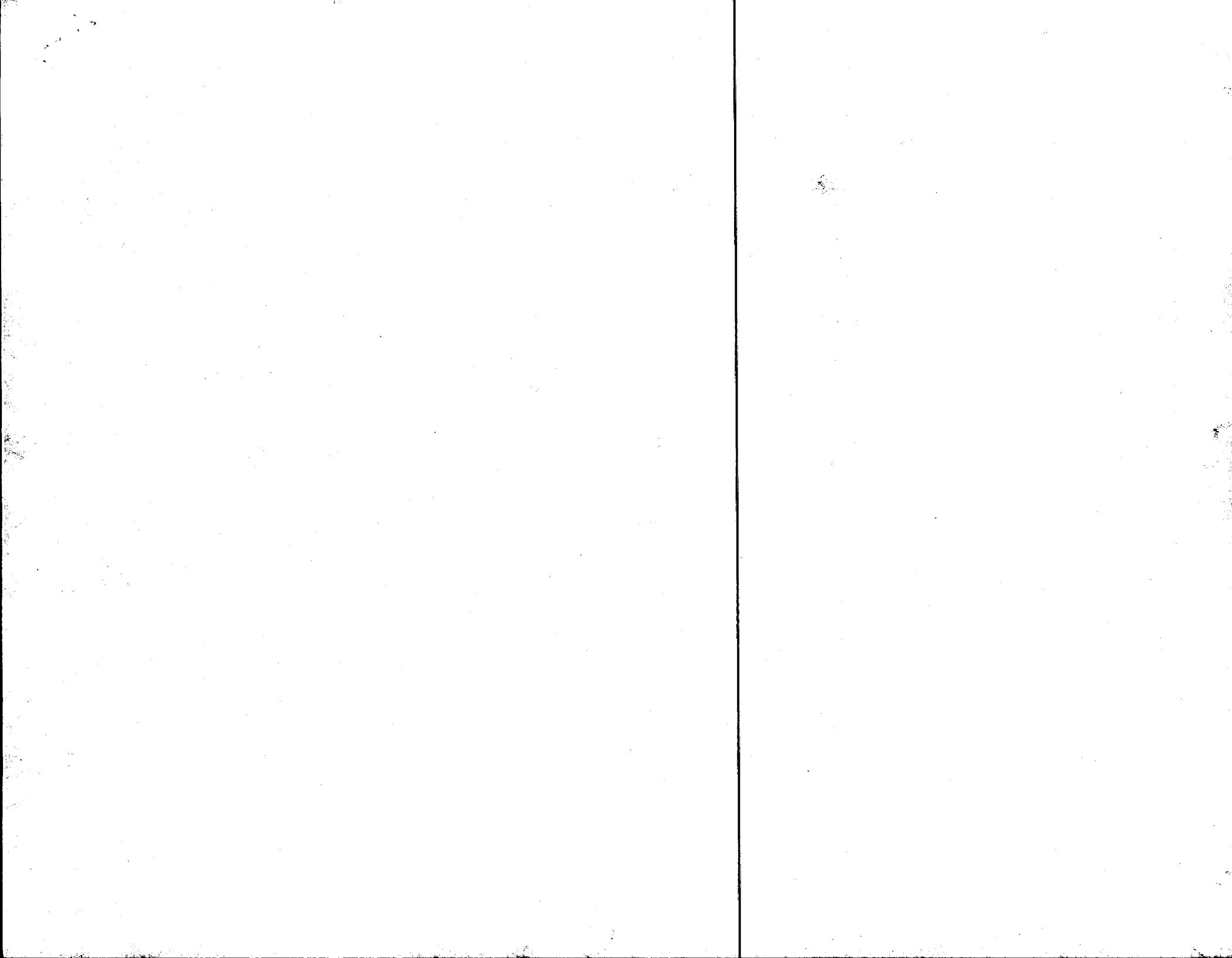
**D2666-1 SADDLE FWD INSIDE HIGH**

ENGRAVE PART NUMBER AND BATCH NUMBER TO MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010



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DART AEROSPACE LTD	Work Order:	33797
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1.13	2.14	3.15	4.16		
A	0.100	0.140		.126	.126	.126	.126		
B	0.100	0.140		.119	.119	.119	.119		
C	2.470	2.510		2.495	2.495	2.495	2.495		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.226	.226	.226	.226		
F	1.313	1.343		1.331	1.331	1.331	1.331		
G	0.240	0.260		.254	.254	.254	.254		
H	0.615	0.685		.650	.650	.650	.650		
I	1.125	1.145		1.140	1.140	1.140	1.140		
J	0.990	1.010		1.000	1.000	1.000	1.000		
K	0.235	0.240		.239	.239	.239	.239		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.116	.116	.116	.116		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.010	6.010	6.010	6.010		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.506	.506	.506	.506		
S	0.313	0.318		.314	.314	.314	.314		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.315	0.322		.319	.319	.319	.319		
W	0.540	0.560		.557	.557	.557	.557		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>SG</i>	Audited by:	<i>SL</i>
Date:	07-09-21	Date:	07/09/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM <i>SL</i> <i>SL</i>	

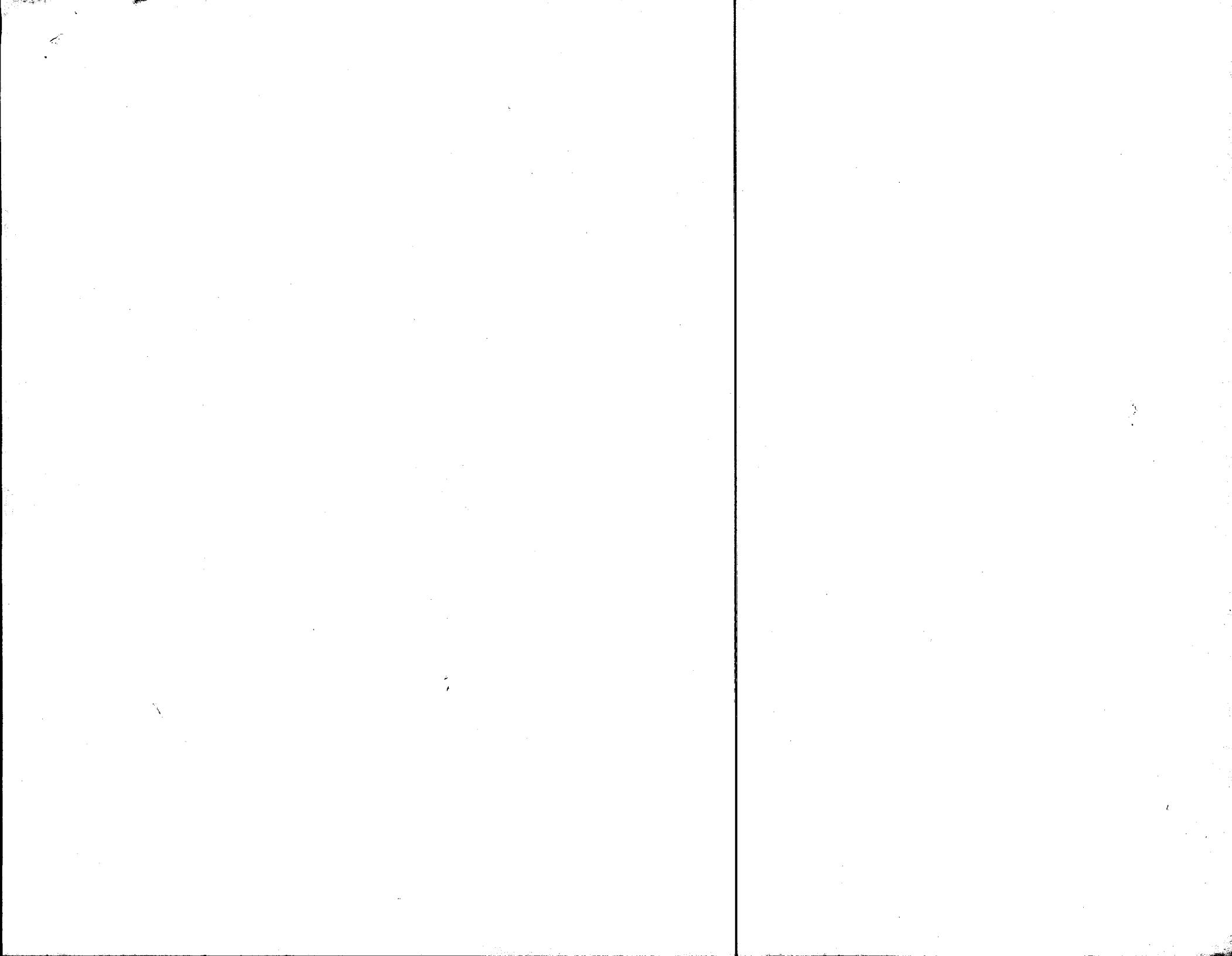
DART AEROSPACE LTD				Work Order:	33797
Description: 206 Saddle, Inboard, Left side				Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1 17	2 18	3 19	4 20		
A	0.100	0.140	.126 →	.126	.126	.126	.126		
B	0.100	0.140	.119 →	.119	.119	.119	.119		
C	2.470	2.510	2.495	2.495	2.495	2.495	2.495		
D	0.100	0.180	.140	.140	.140	.140	.140		
E	0.210	0.230	.226	.226	.226	.226	.226		
F	1.313	1.343	1.331	1.331	1.331	1.331	1.331		
G	0.240	0.260	.254	.254	.254	.254	.254		
H	0.615	0.685	.650	.650	.650	.650	.650		
I	1.125	1.145	1.140	1.140	1.140	1.140	1.140		
J	0.990	1.010	1.000	1.000	1.000	1.000	1.000		
K	0.235	0.240	.239	.239	.239	.239	.239		
L	0.510	0.515	.510	.510	.510	.510	.510		
M	0.100	0.120	.116	.116	.116	.116	.116		
N	1.565	1.585	1.575	1.575	1.575	1.575	1.575		
O	5.990	6.010	6.010 →	6.010	6.010	6.010	6.010		
P	1.245	1.255	1.250	1.250	1.250	1.250	1.250		
Q	2.495	2.505	2.500	2.500	2.500	2.500	2.500		
R	0.490	0.510	.506	.506	.506	.506	.506		
S	0.313	0.318	.314	.314	.314	.314	.314		
T	2.495	2.505	2.500	2.500	2.500	2.500	2.500		
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X	1.674	1.684	1.679	1.679	1.679	1.679	1.679		
Y	0.257	0.262	.258	.258	.258	.258	.258		
Z	0.178	0.198	.188	.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	BSG /	Audited by:	JL
Date:	07/09/25	Date:	07/09/25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	JK JLM



DART AEROSPACE LTD	Work Order:	537017
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1 21	2 22	3	4		
A	0.100	0.140		.125	.125				
B	0.100	0.140		.121	.121				
C	2.470	2.510		2.497	2.497				
D	0.100	0.180		.140	.140				
E	0.210	0.230		.226	.226				
F	1.313	1.343		1.330	1.330				
G	0.240	0.260		.254	.254				
H	0.615	0.685		.650	.650				
I	1.125	1.145		1.140	1.140				
J	0.990	1.010		1.000	1.000				
K	0.235	0.240		.239	.239				
L	0.510	0.515		.510	.510				
M	0.100	0.120		.116	.116				
N	1.565	1.585		1.575	1.575				
O	5.990	6.010		6.010	6.010				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.490	0.510		.506	.506				
S	0.313	0.318		.314	.314				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.362				
V	0.315	0.322		.319	.319				
W	0.540	0.560		.557	.557				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		.258	.258				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>[Signature]</i>	Audited by:	<i>JL</i>
Date:	07-01-25	Date:	07/01/25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>